

Work Order ID 130469

130469

Page 1

Thursday, March 12, 2015 1:08:40 PM

Item ID: D350-689-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Dual High-Back Seat Installation
 Start Date: 3/12/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/12/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MF. Date: 15-3-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-689	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-689-011 CHG007								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ JAN 18 2016

DAS
27
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JAN 18 2016

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DAS
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9-89

DAS
27
9-89

JAN 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130469***130469***

Page 2

Thursday, March 12, 2015 1:08:40 PM

Item ID: D350-689-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High-Back Seat Installation

Start Date: 3/12/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/12/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-011								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JAN 18 2016

MCS JAN 18 2016

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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130469

D350-689-011

Required Date: 3/12/2015

Required Qty: 1.00

Comments: IPP Rev:B03.05.09Reformat; Modify Step 1KJ/RF IPP Rev:C chg003
per DSI 9498 DD 10.02.11 verified by:JLM IPP REV:D 11.11.24 AS PER
ECN11-674 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-689-013		Manufactured	No			110	Each	1.0000	1	1			
D350-689-013													
Floor Provisions													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG027		1							
				127673		1							
D350-689-041		Manufactured	No			110	Each	0.0000	1	1			
D350-689-041													
Dual High Back Seat Assembly													
D3018-1		Manufactured	No			110	Each	5.0000	1	1			
D3018-1													
Seat Cushion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST415		5							
				127183		5							
D3019-1		Manufactured	No			110	Each	5.0000	1	1			
D3019-1													
Back Cushion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST415		5							
				127184		5							

DQA: _____ Date: _____



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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X						D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X					D350-689-013	FLOOR PROVISIONS KIT
		X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
		1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1				X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
1		1				D3018-1	SEAT CUSHION
1		1				D3019-1	BACK CUSHION
	1					D3025-1	BEAM
	1					D3027-1	CLIP
	1					D3027-3	CLIP
	1					D3027-5	CLIP
	4		4			D3027-7	CLIP
				4		D3028-1	STUD
				2		D3029-1	SPRING
				2		D3030-1	LOCK
	1					D3032-1	SPACER
	2					D3033-1	SEAT TRACK
	1					D3234-1	DOUBLER
	2					D3234-5	SPACER
					2	D3808-041	SEAT RAIL ASSEMBLY
					4	D3809-1	SLIDING BLOCK
			1			D3811-041	SEAT TRACK ASSEMBLY
	1		1			D4575-1	BEAM
	1		1			D4575-3	DOUBLER
				1	1	D5162-041	SEAT STRUCTURE ASSEMBLY
			9			MS21042L3	NUT (OR MS21042-3)
	12					MS21059L3	NUTPLATE
	2					MS24693-S273	SCREW
			9			MS24694-S50	SCREW
	6					MS27039-1-10	SCREW
	6					NAS1149D0332J	WASHER (OR AN960JD10L)
			9			NAS1149D0363J	WASHER (OR AN960JD10)

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Revision: C

Date: 14.12.01